

**Work Order ID 59152**

Thursday, May 27, 2010 9:21:43 AM



Page 1

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/27/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:   *M*  Date:   20-5-27  

Tooling:

Date:           

Run Start

QC:                   Date:                   SPC (Y/N):                   Date:                   

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								
100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3793								
304.040	Dwg Rev: <u>  1  </u>								
	Prog Rev: <u>  1  </u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									
120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

1810-5-31

(16)

1810-5-31

(16)

S10605131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59152**

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Page 2

Item ID: D3793-3

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Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/27/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00				(16)			
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form on Brake as per Dwg D3793 using Jigs								
			SB	10/05/31					
140 	QC5- Inspect part completeness to step on W/O	0.00				(16)			
QC	Memo	0.00							
Quality Control									
			S	10/05/31					
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	1112588								
Powder Coating	Memo	0.00							
	START TIME: 10:00am OVEN TEMPERATURE: 320°C FINISH TIME: 10:30am								
			=)	10/06/01					
						X/6			

W/O:		WORK ORDER CHANGES					
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**Work Order ID 59152**

Thursday, May 27, 2010 9:21:43 AM



Page 3

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/27/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				16		BR 10-6-1	
Quality Control									
170	Identify as per dwg & Stock Location: <i>FP-18</i>	0.00							
Packaging	Memo	0.00				16		BR 10-6-1	
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*10/06/01*  
*PL 10-6-01*  
*(14)*

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 27, 2010 9:21:49 AM

Page 1

Work Order ID: 59152



Parent Item: D3793-3



Parent Item Name: Wearshoe

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC  
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	172.9926	1.2828	21.60505	22		
304/316 .040 Sheet													



1810-5-31

## Location

## Loc Qty

## Loc Code

MAT

168.7278

114574

168.7278

MAT20

4.2648

112885

2.7475

113062

1.5173

114574

(15)

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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W/O:		WORK ORDER CHANGES					
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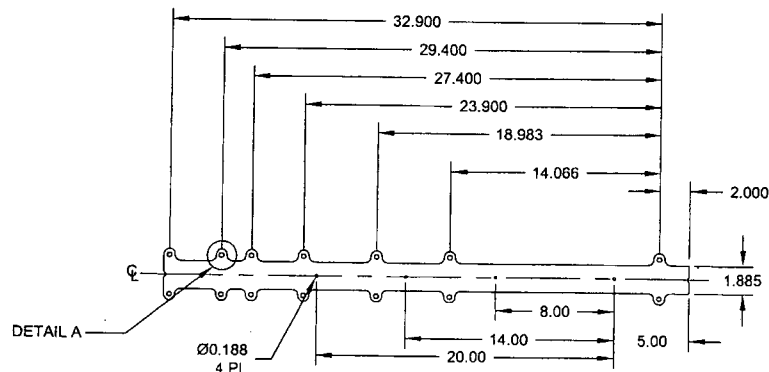
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

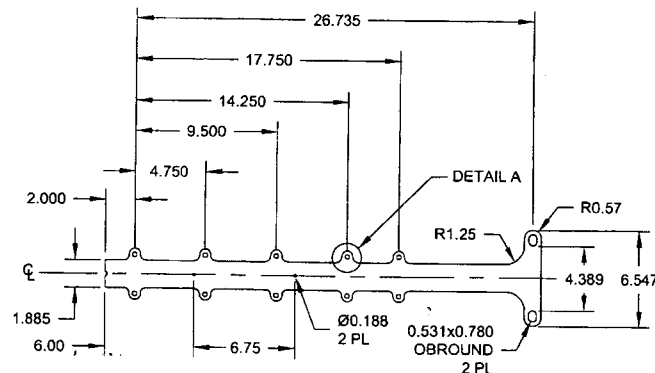
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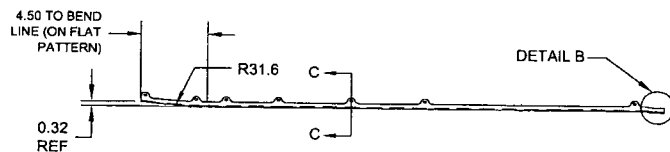
8 7 6 5 4 3 2 1



**D3793-1F FLAT PATTERN**



**D3793-3F FLAT PATTERN**



**D3793-1 BEND DETAIL**  
(MAKE FROM D3793-1F)



**D3793-3 BEND DETAIL**  
(MAKE FROM D3793-3F)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 89152

BS10-5-27

RELEASED  
08.05.14

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3793 TITLE WEARSHOE REV. A SHEET 1 OF 2 SCALE NTS			
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8 7 6 5 4 3 2 1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

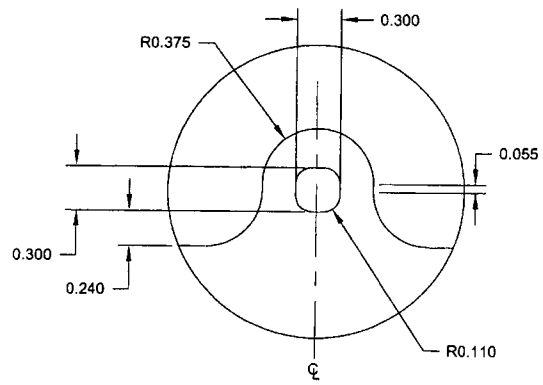
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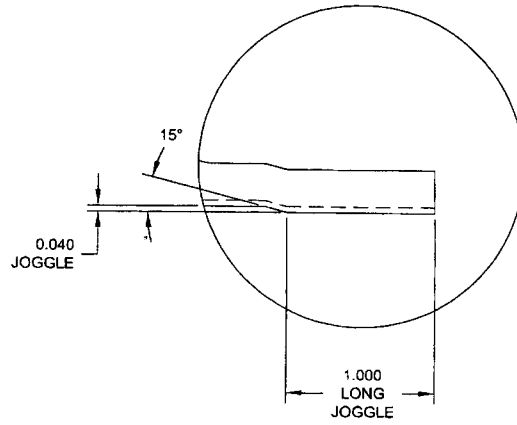
**NOTE:** Date & initial all entries

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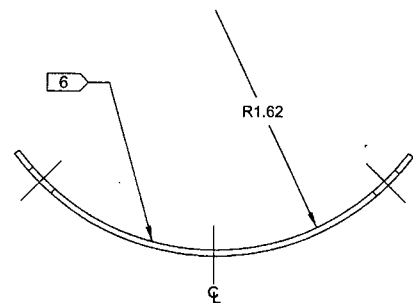
D  
C  
B  
A



**DETAIL A**  
SCALE 10X



**DETAIL B**  
SCALE 10X



**SECTION C-C**  
SCALE 10X

W/0 59/52

**RELEASED**  
08-05-14

8 7 6 5 4 3 2 1

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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